

Work Order ID 76033

November-03-11 8:59:19 AM

76033

Page 1

Item ID: D350-589-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Side Door Latch Modification

Stop ***NS2***

Start Date: 03/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/11/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 11/11/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00

100

DOCUMENT CONTROL ✓

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

Sulu/25

11/11/24

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

11/11/24

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

Sulu/25

(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76033***76033***

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Revision ID:

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Item Name: Side Door Latch Modification

Start Date: 03/11/2011 Start Qty: 5.00

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Cust Item ID:

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MF
11-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 76033

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S/S AN960JD10 Washer	NAS1149D0363J	Purchased	No			105	Each	0.0000	3 15	15			
AN960.ID10									**				
S/S D2237 Striker Plate		Manufactured	No			105	Each	41.0000	3 15	15			
D2237									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		41							
				66139		2							
				73702		39							
S/S D2583 Latch Bracket		Manufactured	No			105	Each	22.0000	3 15	15			
D2583									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		22							
				74073		22							
S/S D2585 Mounting Channel		Manufactured	No			105	Each	100.0000	3 15	15			
D2585									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST017		100							
				73297		34							
				74488		66							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2586

Manufactured No

105

Each

120.0000

D2586

Door Latch

**

Location

Loc Qty

Loc Code

ST204

120

73296

80

74489

40

Manufactured No

105

Each

33.0000

D2587

D2587

Door Slug, 350 Hinge

**

Location

Loc Qty

Loc Code

ST017

33

74522

33

Manufactured No

105

Each

57.0000

D2589

D2589

Keys, Key Chain, 350 Hinge

**

Location

Loc Qty

Loc Code

ST018

57

58194

57

Purchased No

105

Each

2,424.000

MS20470AD4-5

MS20470AD4-5

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

2424

116893

68

118405

2356

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 03/11/2011

Required Date: 17/11/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

105

Each

9,719.000

3 15

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

739

117441

16

117885

42

118451

62

118927

619

ST516

6000

119017

6000

ST518

2980

119075

2980

MS27039-1-15

Purchased

No

105

Each

63.0000

3 15

**

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

ST291

63

118093

25

118574

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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